

Work Order ID 119856

May-28-14 7:47:34 AM

D 4 1 4 9 - 1

B 1 1 9 8 5 6

119856

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Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Aft

Start Date: 5/28/14 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4149	C

100 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: C

OPEN TO 0.252" HOLES TO FINISH SIZE AS PER DWG ✓

Deburr as required

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

Quality Control

Work Order ID 119856

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Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Aft

Start Date: 5/28/14 Start Qty: 30.00

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Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 30.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/6/16

32
can

150 Identify as per dwg & Stock Location: 8094 0.00

0.00

150

Packaging

Memo

0.00

Packaging

32x 14-6-17

DAS
26
9-89

160 QC21- Final Inspection - Work Order Release 0.00

0.00

160

QC

Memo

0.00

Quality Control

ML 14-6-18

14-6-17

Picklist Print

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Work Order ID: 119856

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Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 5/28/14

Required Date: 5/30/14

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

157.0000

0.1355

⑤

**DAS
23**

9-89 14-06-7

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

157

122521

30

M128254

127

128254

DART AEROSPACE LTD		Work Order: 114856
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.132"	-		✓	Jkm05
Ø0.191	+0.005/-0.001	0.194"	-		✓	
Ø0.257	+0.006/-0.001	0.258"	-		✓	
Ø0.38	+0.006/-0.001	0.380"	-		✓	
0.380	+/-0.010	0.384"	-		✓	
0.469	+/-0.010	0.467"	-		✓	
0.310	+/-0.010	0.312"	-		✓	
0.750	+/-0.010	0.757"	-		✓	
3.25	+/-0.030	3.25"	-		✓	
0.65	+/-0.030	0.65"	-		✓	
0.63	+/-0.030	0.63"	-		✓	
5.46	+/-0.030	5.46"	-		✓	
3.80	+/-0.030	3.80"	-		✓	
2.13	+/-0.030	2.13"	-		✓	
1.313	+/-0.010	1.317"	-		✓	
0.625	+/-0.010	0.628"	-		✓	
0.375	+/-0.010	0.372"	-		✓	
1.175	+/-0.010	1.175"	-		✓	
0.752	+/-0.010	0.752"	-		✓	
1.588	+/-0.010	1.588"	-		✓	
1.587	+/-0.010	1.587"	-		✓	
11.15	+/-0.030	11.15"	-		✓	Jkm08
0.750	+/-0.010	0.752"	-		✓	
1.55	+/-0.030	1.55"	-		✓	
1.12	+/-0.030	1.12"	-		✓	
8.42	+/-0.030	8.42"	-		✓	
2.70	+/-0.030	2.70"	-		✓	
0.125	+/-0.010	0.116"	-		✓	
Ø0.252	+0.003/-0.000	0.253"	-		✓	-

Measured by: DAS 23 98	Audited by: DAS 27 98	Preliminary Approval:
Date: 14-06-7	Date: 14/10/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

